

Work Order ID 144456

April 18, 2016 3:00:12 PM

144456

Page 1

Item ID: D412-761-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Modified Latch Mechanism, LH
 Start Date: 4/26/2016 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 5/6/2016 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: SH Date: 20160428 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr	DAS 6 9-89							
IIN D412-761	E								

100 Document Control 0.00
100 DOCUMENT CONTROL
 DC Memo 0.00
 Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPP D412-761-043 CHG002

DAS
28
9-89
6x

AUG 09 2016

110 Pick Kit 0.00
110
 Packaging Memo 0.00
 Packaging

PC
 DAS
27
9-89

JUL 26 2016

120 QC4- 100% Inspect kits for completeness 0.00
120
 QC Memo 0.06
 Quality Control

6x
 DAS
28
9-89

AUG 09 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 144456

April 18, 2016 3:00:12 PM

144456

Page 2

Item ID: D412-761-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Modified Latch Mechanism, LH

Stop ***NS2***

Start Date: 4/20/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/6/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-761-043 Location:FG020								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.20							
Quality Control									

X 6 DAS
27
9-89DAS
28
9-89

AUG 09 2016

16.08.10
2m 16/08/09

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								

April 18, 2016 3:00:18 PM

144456

D412-761-043

Required Qty: 2.00

Comments: IPP Rev:A 09-01-13 rev.C as per dwg DD verified by:EC IPP REV:B
11.11.29 AS PER DSI9580 DD VRF:EC IPP REV:C 12.07.23
ECN12-568 chg002 DD VRF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3589-041		Manufactured	No			110	Each	0.0000	1	26			DAS 27 9-89
D3589-041													
Latch Assembly													
D3589-047		Manufactured	No			110	Each	0.0000	1	26			DAS 27 9-89
D3589-047													
Fwd Guide													
D3589-049		Manufactured	No			110	Each	0.0000	1	24			DAS 27 9-89
D3589-049													
Aft Guide													
MS16997-24		Purchased	No			110	Each	24.0000	2	12			DAS 27 9-89
MS16997-24													
SCREW													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST316			24					
					m132656			4					
					m133316			20					
NAS1149DN632J		Purchased	No			110	Each	747.0000	2	7/2			DAS 27 9-89
NAS1149DN632.J													
Washer													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST264			747					
					m133860			47					
					m134370			700					

JUL 2 6 2016

Picklist Print

Page 2

April 18, 2016 3:00:19 PM

Work Order ID: 144456

144456

Parent Item: D412-761-043

D412-761-043

Parent Item Name: Modified Latch Mechanism, LH

Start Date: 4/20/2016

Required Date: 5/6/2016

Start Qty: 2.00

Required Qty: 2.00

MS21042L06

Purchased

No

110

Each

234.0000

2

MS21042L 06

Nut

4 (12)
X m134962 PC DAS 27 9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST303

234

m134294

84

m134474

50

m134537

100

ALL 267006

6.0 PARTS LIST, FULL VERTICAL REFERENCE DOOR MOD KITS

QTY -041	QTY -041A	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	QTY -141	PART NUMBER	DESCRIPTION
									D412-761-011	FULL VERTICAL REFERENCE DOOR, LH
									D412-761-011A	FULL VERTICAL REFERENCE DOOR, LH
X									D412-761-041	FULL VERTICAL REFERENCE DOOR KIT, LH
	X								D412-761-041A	FULL VERTICAL REFERENCE DOOR KIT, LH
		X	1						D412-761-043	MODIFIED LATCH MECHANISM KIT, LH
1	1		X						D412-761-045	LARGE BUBBLE WINDOW KIT, LH
1	1			X					D412-761-047	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
1					X				D412-761-049	ARMREST KIT, LH
	1					X			D412-761-051	ARMREST KIT, LH
1	1						X		D412-761-053	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
								X	D412-761-141	VENT KIT
		1							D3589-041	LATCH ASSEMBLY
		1							D3589-047	FORWARD GUIDE
		1							D3589-049	AFT GUIDE
		2							MS16997-24	SCREW
		2							MS21042L06	NUT
		2							NAS1149DN632J	WASHER (OR AN960JD6L)
			1						D3676-1	LARGE BUBBLE WINDOW
			1						D3678-1	PLACARD
			1						D3678-3	PLACARD
			1						D3678-5	PLACARD
			1						D3700-1	INBOARD WINDOW DOUBLER
			1						D3700-3	OUTBOARD WINDOW DOUBLER
			1						D3701-1	FLOOR DOUBLER
			1						D3702-1	FORWARD DOUBLER
			1						D3703-1	AFT DOUBLER
			1						D3703-3	AFT CORNER DOUBLER
			1						D3703-5	AFT CAP
			1						D3704-1	ESCUTCHEON
			1						D3704-3	ESCUTCHEON
			1						D3708-1	ANGLE
			1						D3708-3	ANGLE
			1						D3709-1	ANGLE
			1						D3709-3	ANGLE
			1						D3802-1-135	SEAL
			1						DT9458	CUTTING TEMPLATE
			26						AN3-7A	BOLT
			26						MS21042L3	NUT
			1						MS24694-C5	SCREW (OR MS24694-S5)
			1						MS24694-C13	SCREW (OR MS24694-S13)
			1						NAS43DD3-24	SPACER
			52						NAS1149D0363J	WASHER (OR AN960JD10)

(CONTINUED ON PAGE 12)

• COPYRIGHT © 2008 BY DART AEROSPACE LTD. •
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
 OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: F
 Date: 16.05.26

Work Order ID 144456

April 18, 2016 3:00:12 PM

144456

Page 1

Item ID: D412-761-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Modified Latch Mechanism, LH

Start Date: 4/20/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/6/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: SW

Date: 120160418 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-761	E								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-761-043 · CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.06							
Quality Control									

DAS
21
9-89

JUL 26 2016

6